

Date: Friday, 01/08/2008 3:28:48 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : MOUNTING ANGLE |
| Job Number | : 40936 | | |
| Estimate Number | : 10509 | | |
| P.O. Number | : | Part Number | : D2564 |
| This Issue | : 01/08/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D2564 REV. B1 |
| First Issue | : // | Project Number | : N/A |
| Previous Run | : 38026 | Drawing Revision | : B1 |
| Written By | : | Material | : |
| Checked & Approved By | : <u>MD 08-8-05</u> | Due Date | : 22/08/2008 |
| Comment | : Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF | Qty: | 51 / 50 Um: Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------|-----------------|
| 1.0 | D6207 | Angle Extrusion |
|-----|-------|-----------------|



Comment: Qty.: 0.0962 f(s)/Unit Total : 4.8090 f(s)
 Angle Extrusion
 Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)
 (D6207) Batch: M105462

25 08/08/06 (50)

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

28 08/08/06 (50)

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA276 Rev: A & Dwg D2564 Rev: B1

2-Deburr if necessary

29 08/08/07 (50)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

29 08/08/07

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

31 08/08/08 87

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:28:48 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 40936

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5T36

Lu 8/8

54

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(51)

Comment: FINAL INSPECTION/W/O RELEASE

2008/08/11

Job Completion



MF 08-08-08

H:\FORM

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

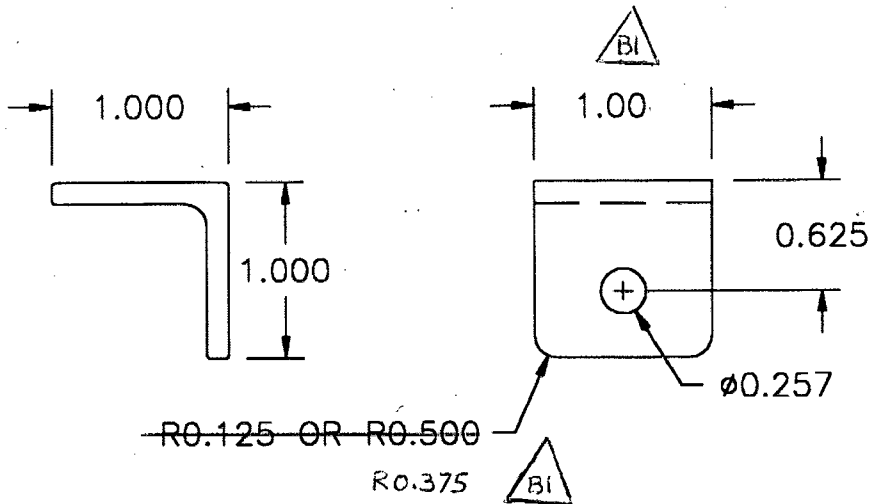
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | | | |
|------------------|----------|-------------------------|--|--|--------------|
| DESIGN | | DRAWN BY | | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| MIKE M | | MIKE M | | DRAWING NO. D2564 | REV. B |
| CHECKED BW | | APPROVED BW | | | SHEET 1 OF 1 |
| DATE 96:04:30 | | TITLE MOUNTING ANGLE | | | SCALE 1:1 |
| B | 97:05:06 | | MODIFIED DIMENSIONS | | |
| BI | 02.09.17 | | R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000 | | |

RELEASED
97/05/06 BWNOTES:

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40936